

~ Date: Thursday, 13/11/2008 1:09:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PEDAL ASSEMBLY		
Job Number	: 43431			Part Number	: D412704041		
Estimate Number	: 11005			Drawing Number	: D412-704-041 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 05/12/2008		
Previous Run	: 38858			Qty:	3		
Written By	:			Um:	Each		
Checked & Approved By	: JUL 08. 11.14						
Comment	: Est Rev:B 05.01.28 Removed hardware on Step 2; Added Figures 1-3 KJ/RF Est Rev:C 06.03.08 Re-format EC Est Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM Est Rev:E 07.05.02 Reformat EC Est Rev:F 08-10-08 as per revB DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description :	
1.0	D3204041			Release Pedal Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)			
	Pick:				
	Qty	Part number	Description	batch	
	1	D3204-041	Pedal Assembly	B43446	
2.0	D32051			Pedal Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)			
	Pick:				
	Qty	Part number	Description	batch	
	1	D3205-1	Bracket	B35804	
3.0	D32053			Back Plate	
	Comment: Qty.: 1.0000 Each(s)/Unit	Total : 4.0000 Each(s)			
	Pick:				
	Qty	Part number	Description	batch	
	1	D3205-3	GHW Bracket	B35209	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	D32061	Pedal Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3206-1	Pedal arm

batch
B36535



Epo8/12/04

5.0 D3209041 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	D3209-041	Bracket

batch
B37170 x 1 , B 38190 x 2.



Epo8/12/04

6.0 AN310A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN3-10A	Bolt

batch
M17566



Epo8/12/04

7.0 AN3154R Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN315-4R	Nut

batch
M17566



Epo8/12/04

8.0 AN410A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description
1	AN4-10A	Bolt

batch
M107178



Epo8/12/04

W/O:		WORK ORDER CHANGES					
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Job Number: 43431

Part Number: D412704041

Job Number:



Seq. #:	Machine Or Operation:	Description :
9.0	AN412A	Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN4-12A	Bolt	<u>M106918</u>



EP 08/12/04

10.0	AN413A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	AN4-13A	Bolt	<u>M109285</u>

EP 08/12/04

11.0	AN960JD10	Washer
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	AN960JD10	Washer	<u>M109061</u>

EP 08/12/04

12.0	AN960JD416	Washer
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Comment: Qty.: 11.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part number	Description	batch
11	AN960JD416	Washer	<u>M109249</u>

EP 08/12/04

13.0	AN960JD416L	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	AN960JD416L	Washer	<u>M110022</u>

EP 08/12/04

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 MS21042L3 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty	Part number	Description	batch
3	MS21042L3	Nut	1109031



Eps 12/12/04

15.0 MS21042L4 Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part number	Description	batch
5	MS21042L4	Nut	1108445

Eps 12/12/04

16.0 MS24694S102 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS24694S102	Screw	1141604

Eps 12/12/04

17.0 MS951910 Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	MS9519-10	Bolt	1100290

Eps 12/12/04

18.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble pedal as per Dwg D412-704-041

Tighten & Torque Bolts as per Dwg D412-704-041



Eps 12/12/04 (3)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/12/04 +3

Comment: INSPECT WORK TO CURRENT STEP

20.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0 AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part number	Description	batch
4	AN960JD10L	Washer	M105993

SP

22.0 AN36A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part number	Description	batch
2	AN3-6A	Bolt	M109452

SP

23.0 MS21042L3

Nut



34

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M109031

8/12/04

SP

24.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



34

Comment: INSPECT 100% KITS FOR COMPLETENESS

25.0 PACKAGING 1

PACKAGING RESOURCE #1



34

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP 43368

8/12/04

SP

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #: Machine Or Operation:

Description :

26.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/04 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

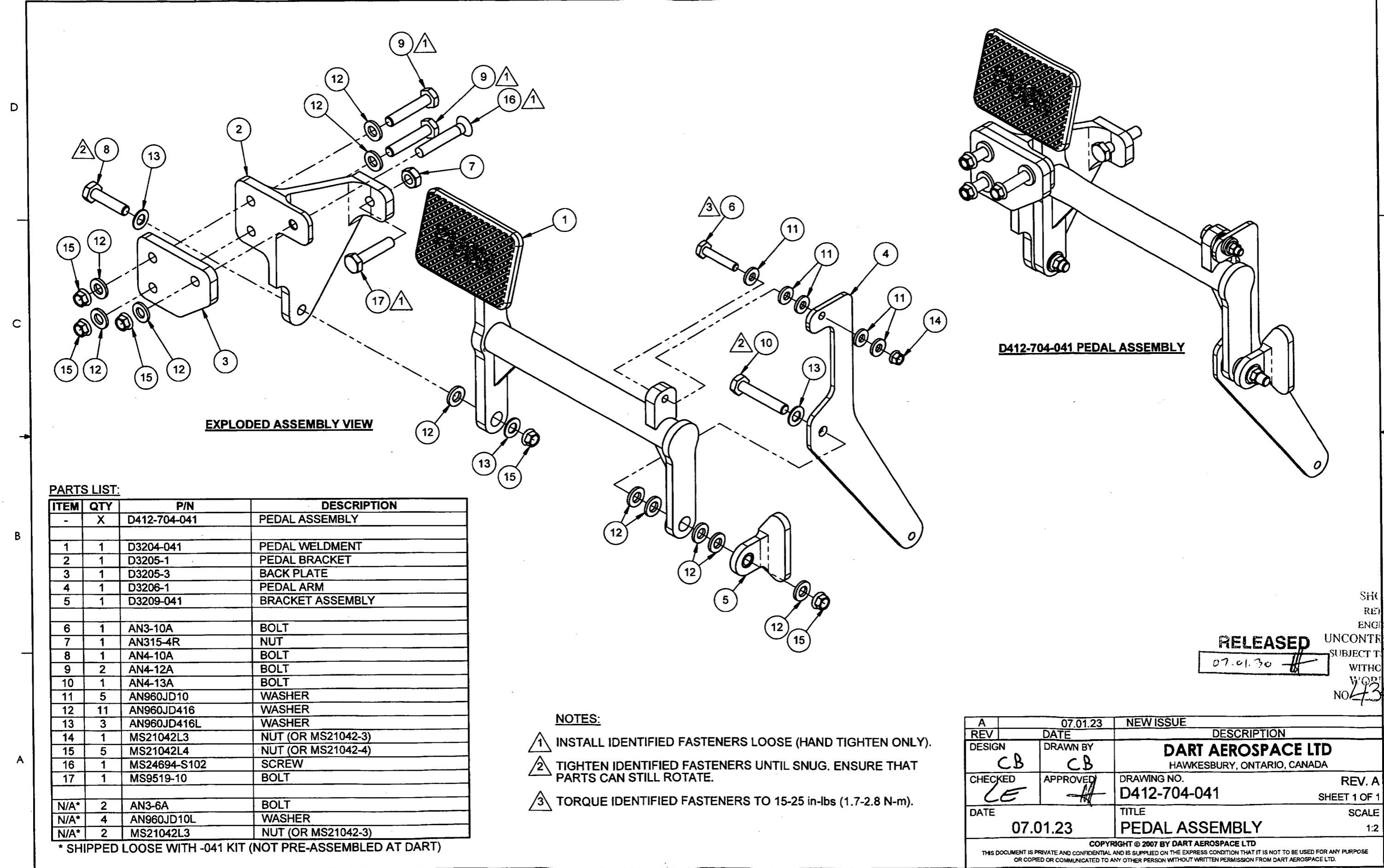
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
07.01.23
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHHELD NOTICE
WORK ORDER
NO 43431

A	07.01.23	NEW ISSUE
REV	DATE	DESCRIPTION
CB	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CE	CE	DRAWING NO. D412-704-041
DATE	TITLE	REV. A
07.01.23	PEDAL ASSEMBLY	SHEET 1 OF 1
SCALE		1:2

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